

# Work Order ID 86030

June-19-12 4:06:43 PM

\*86030\*

Page 1

Item ID: D3296-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Door Assembly

Start Date: 19/06/2012 Start Qty: 8.00

\*8\*

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 8.00

\*8\*

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/06/10 Tooling:

Run Start \*NR1\*

QC: Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3296	Rev A

100 0.00

\*100\*

Small Fab

Small Fab

Memo

0.00

Small Fab

Fabricate & assemble as per Dwg D3296.

Transfer drill using DT8470 & DT9521

110

QC5- Inspect part completeness to step on W/O

0.00

\*110\*

QC

Memo

0.00

Quality Control

120

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

\*120\*

Powdercoat

Memo

0.00

Powder Coating

START TIME: OVEN TEMPERATURE:

FINISH TIME:

3200F

7:50

ml 21279

8X

12/08/10

(8X)

ML

8X

12/08/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

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**\*86030\***

Page 2

Item ID: D3296-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Door Assembly

Start Date: 19/06/2012 Start Qty: 8.00

**\*8\***

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 8.00

**\*8\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC3- Inspect Part Finish

0.00

**\*130\***

QC

Memo

0.00

Quality Control

8x of 12/08/14

140

Small Fab

0.00

**\*140\***

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D3296

8x 12/08/15

150

QC5- Inspect part completeness to step on W/O

0.00

**\*150\***

QC

Memo

0.00

Quality Control

Smb  
12.8.15

DAS  
16  
2-23 12/08/15

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Work Order ID 86030

June-19-12 4:06:43 PM

\*86030\*

Page 3

Item ID: D3296-041  
Revision ID:  
Item Name: Door Assembly  
Start Date: 19/06/2012 Start Qty: 8.00  
Required Date: 03/07/2012 Req'd Qty: 8.00  
Reference:

Accept

\*N900040100\*

Setup Start \*NS1\*  
Stop \*NS2\*

Cust Item ID:  
Customer:

Approvals: Process Plan: Date: Tooling: Date:  
QC: Date: SPC (Y/N): Date:

Run Start \*NR1\*  
Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: 218	0.00	SD						
*160*			SL						
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
*170*									
QC	Memo	0.00							
Quality Control									

12/08/16

MLJ 12/08/16

MLJ 12/08/16

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

June-19-12 4:06:47 PM

Page 1

Work Order ID: 86030

\*86030\*

Parent Item: D3296-041

\*D3296-041\*

Parent Item Name: Door Assembly

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP C05.10.14Added step 14KJ/EC  
IPP Rev:D Revised Steps 06-11-20 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3161-7 *D3161-7* Hinge 14.0"		Manufactured	No			100	Each	13.0000	1	8			**
<div> <div>Location</div> <div>GA</div> <div>84607</div> </div> <div> <div>Loc Qty</div> <div>13</div> <div>13</div> </div> <div> <div>Loc Code</div> </div>													
D3161-9 *D3161-9* Hinge 17.0"		Manufactured	No			100	Each	12.0000	1	8			**
<div> <div>Location</div> <div>ST031</div> <div>84608</div> </div> <div> <div>Loc Qty</div> <div>12</div> <div>12</div> </div> <div> <div>Loc Code</div> </div>													
D3296-1 *D3296-1* Door Panel		Manufactured	No			100	Each	0.0000	1	8			**
D3296-3 *D3296-3* Door Panel		Manufactured	No			100	Each	4.0000	1	8			**
<div> <div>Location</div> <div>ST233</div> <div>75061</div> </div> <div> <div>Loc Qty</div> <div>4</div> <div>4</div> </div> <div> <div>Loc Code</div> </div>													

386857 (8x)

38673 (8x)

EP 5/2/08/10

EP 5/2/08/10

EP 5/2/08/10

EP 5/2/08/10

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 2

Work Order ID: 86030

\*86030\*

Parent Item: D3296-041

\*D3296-041\*

Parent Item Name: Door Assembly

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 8.00

Required Qty: 8.00

MS20470AD4-6

Purchased

No

100

Each

2,424.000

1

8

\*MS20470AD4-6\*

Rivet, Universal Head

\*\*

*GP 12/08/15*

8

Location

Loc Qty

Loc Code

ST319

2424

117395

16

118927

279

119109

12

120142

117

121524

2000

D2137

Manufactured

No

140

Each

33.0000

1

8

\*D2137\*

Decal - No Step

\*\*

*GP 12/08/15*

7

1

Location

Loc Qty

Loc Code

GA

21

79837

1

84438

20

ST

12

108012

0

45851

0

52033

0

83540

12

D2419

Manufactured

No

140

Each

26.0000

1

8

\*D2419\*

Handle

\*\*

*GP 12/08/15*

8

Location

Loc Qty

Loc Code

GA

26

73717

6

82836

8

85042

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

Work Order ID: 86030

\*86030\*

Parent Item: D3296-041

\*D3296-041\*

Parent Item Name: Door Assembly

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 8.00

Required Qty: 8.00

D2462  
\*D2462\*  
Seal

Manufactured No

140 f 318.6008 0.3333 2.6664  
\*\*

## Location

## Loc Qty

## Loc Code

ST404

318.6008

48530

318.6008

D2728-1  
\*D2728-1\*  
Dart Logo label

Manufactured No

140 Each 0.0000 0 0

MS20470AD4-4

Purchased No

140 Each 9,451.000 25 200

\*MS20470AD4-4\*  
Rivet, Universal Head

## Location

## Loc Qty

## Loc Code

ST313

4418

122027

2600

122063

1818

ST319

5033

116188

136

116391

66

118614

1000

119109

26

121011

5

121556

800

121652

3000

NAS1149DN632J Purchased No

140 Each 180.0000 1 8

\*NAS1149DN632.J\*  
Washer

## Location

## Loc Qty

## Loc Code

ST298

180

118428

180

June-19-12 4:06:47 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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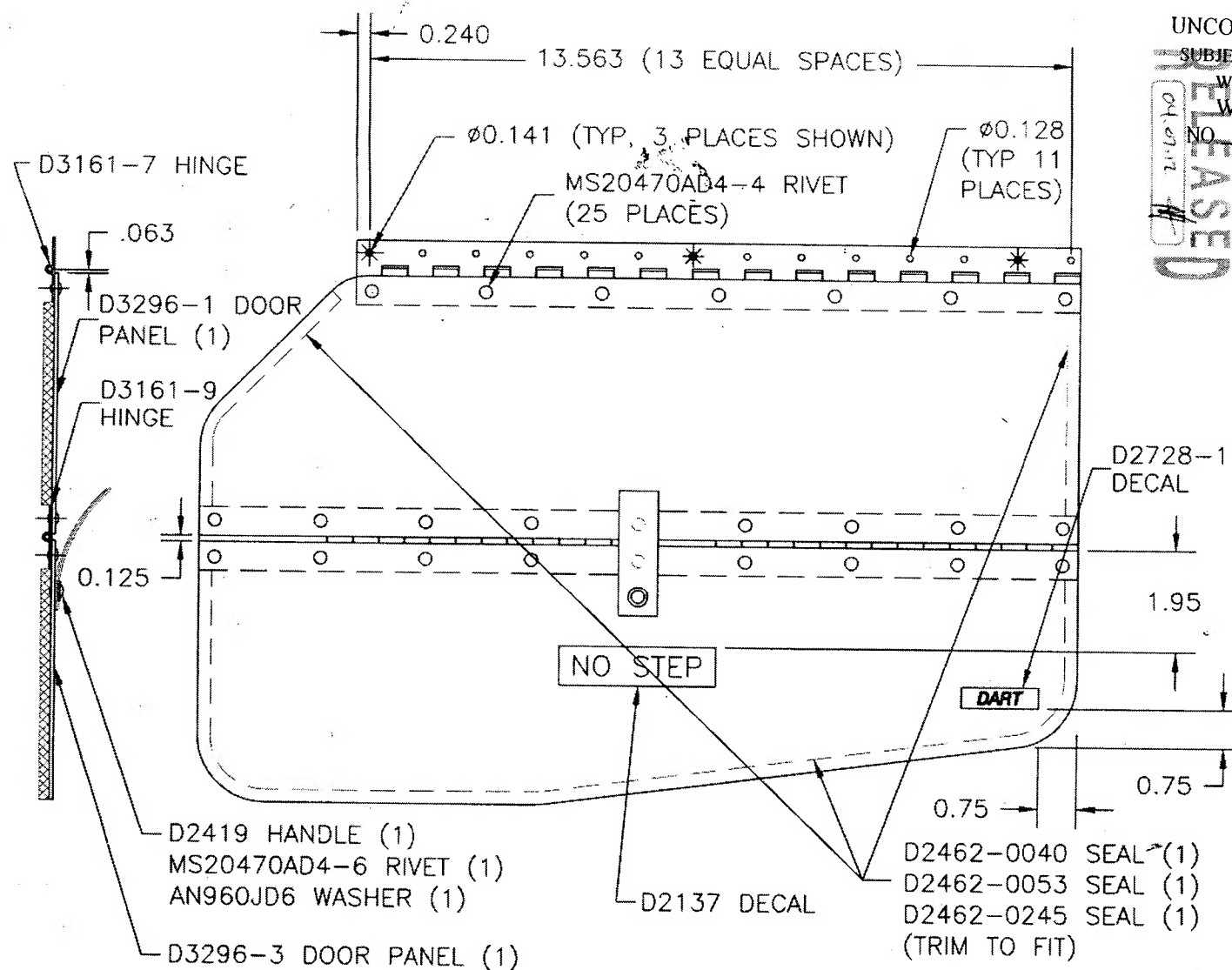
**NOTE:** Date & initial all entries

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 86030

**DART**



DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. A
04.06.28	D3296	1 OF 2
	TITLE	SCALE
	DOOR ASSEMBLY	
A	04.06.28	NEW ISSUE



#### D3296-041 DOOR ASSEMBLY

- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

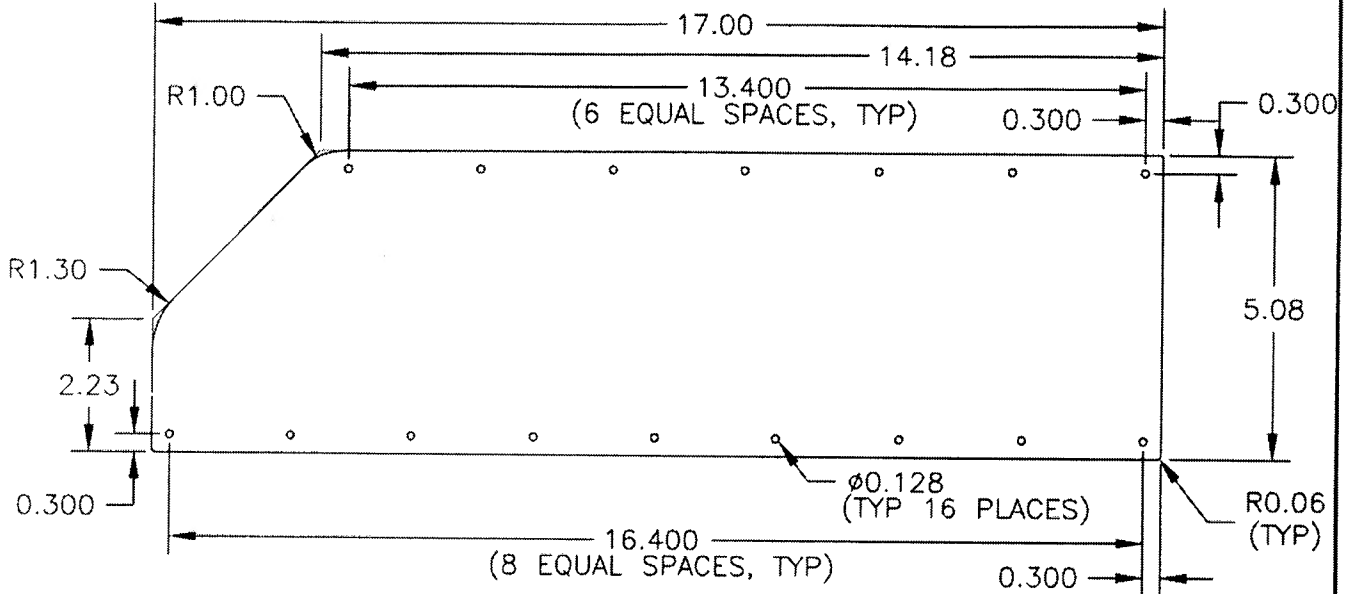
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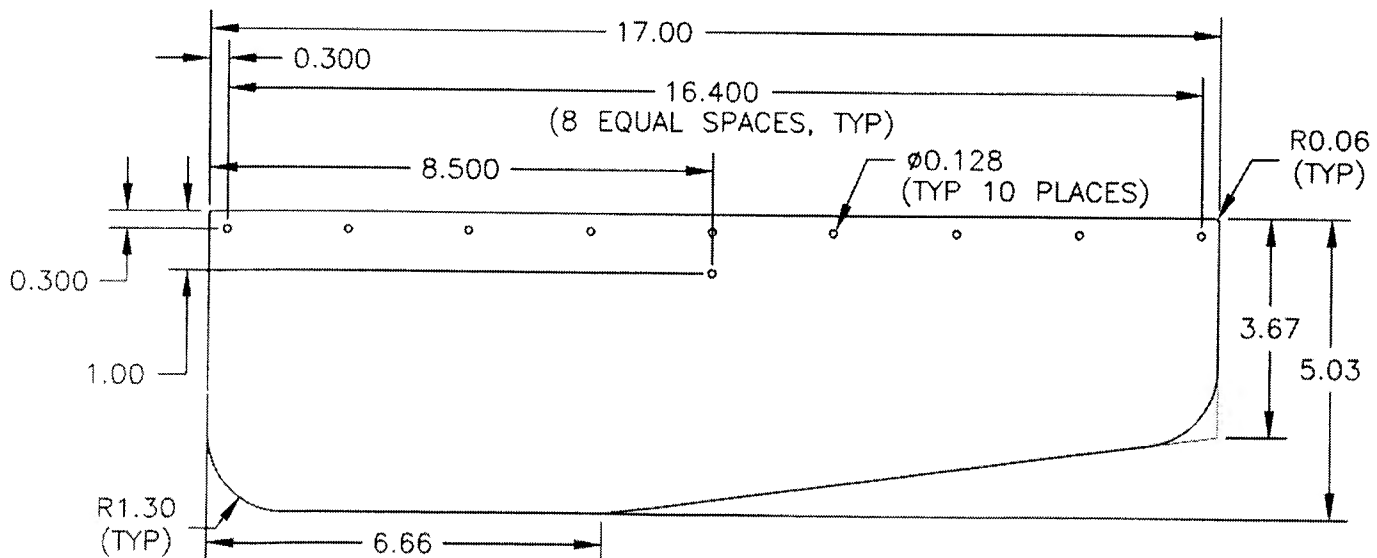
26030



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3296	REV. A 2 OF 2
DATE 04.06.28		TITLE DOOR ASSEMBLY	SCALE 1:3



**D3296-1 DOOR PANEL**



**D3296-3 DOOR PANEL**

D3296-1 AND D3296-3

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK  
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**RELEASED**  
04.07.12

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